Work Order ID 10 October 29-13-10-13-15	08897		*10	8897*			•		•	Page !	l
Revision ID: 29381 Revision ID: 206 Saddle L	eft Side		Accept	*Nou	ัก4ก	100)* s	etup Start Stop	. 17	S1* S2*	
Start Date: 10/29/13 Required Date: 10/29/13 Reference:	Start Qty: 4.00 Req'd Qty: 4.00	*4*		Cust Item Customer		in e			•	٠	
Approvals: Process Pl	an: MUJ .	Date: \\\\\	Tooling:	· I			. R	tun Start	17	R1*	
. 4		•			Date:	** **	ř	Stop	*N	R2*	
Sequence ID/ Work Center ID	Operation Description	·.	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr Re	vision Nbr		3.								
D2938 Re	v C									•	
100 *100* HAAS 1	HAAS CNC VERTICAL	MACHINING #1	0.00	Cm/13/16/	11/05		6				
HAAS CNC vertical machine #1	Program par number are p inspect as pe	t number and batch number or ogrammed correctly 2-Nor dwg D2938 & attached visually inspect as per	Aachine Step No 1 of Fo	r and batch olio and visually	, X				٠		
s ^{ti}											
*110 *1110*	CONVENTIONAL MILI	LING MACHINE	0.00	AR 13/11	/05			6.0			
Mill Conv	Memo	•	0.00	* · , · - · - ////	103						ښ. د
Conventional Milling Machine	Machine Ke	yway and inspect per attac	thed dimension sheet								
	•					•					
120	QC1- Inspect dimensions	s to dimension sheet	0.00	on/13/11	105		.* •				
120 QC Quality-Control	Мето	V Section 1	0.00		rita de la secono de la compansión de la		4	Ø.		·	-

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15

DQA:			Date:											*	A PT
04.61			D-4			WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					AEROSPACE
QA Closed:			Date:					T			W	ork Order up	odate only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
	_					Rework	1		Skid-tube	Crosstube]	Water Jet	\neg	Engineering
Part N	۱o.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	ᅥ	Quality
	_					Use-as-is	1	•	noforming	Finishing	\vdash	4	re/Packaging	┪	Other
NCR N	No					Suspected Unapproved]		Large Fab	Composite]	Supplier		
Root	T				Desci	ription of work order update	T -	<u>I</u> Initial	Ac	tion	-	Sign &		一	
Cause		Date	Step	Qty		or non-conformance		nief Eng		ription		Date	Verification	ı	QC Inspector
Design								<u> </u>		·				\exists	
Doc/Data															
Equip/Tooling															
Handling/Pre							1								
Material															
Operator															
Offset/Setup	Ш														
Process	Ш														
Supplier						•							ļ		
Training													.		
Transport															
Unapproved															
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Landii						General	_	_				-	_		
	_	ending			<u> </u>	Bend	L	Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
	_	entre No	t Concer	ntric		BOM/Route	L_	Grain			L	Over/Under	tolerance		Set-up
	-	racks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct [Temperature/Cure
	_	rimp/Kin	k/Ripple,	/Wave		Burrs		Inspecti	on Incomplete/U	nqualified		Part Lost/Mi	ssing		Weld
		uffs				Contamination	<u></u>	Instruct	ions Incomplete/I	Unclear	L	Part Moved			Wrong Stock Pulled
	_	rushing			<u> </u>	Countersink		Misalig	ned/off center			Positioned V	Vrong _		
		eat Trea				Cut Too Short		Mislabe	led			Power Loss/	Surge		Other
	_	rspection	• .	Tube		Drawing	L_	Misread	I						
	_	1arks/Ch				Drill Holes		Off-set							
		urning Se				Finish		Out of 0	Calibration						
	ΙV	Vave/Twi	st in Tub	e	- 1	Fit/Function		Out of s	Sequence						

108897

Page 2

10:13:15 AN	1		,								-
D2938-1			Accept	*N90	0040	100)* s	-	I M	S1*	i h
206 Saddle L	Left Side								"17	S 7"	
10/29/13	Start Qty: 4.00	*4*		Cust Ite	m ID:						
: 10/29/13	Req'd Qty: 4.00	*4*		Custome	er:						
Process P	lan:	Date:	Tooling:		Date:		F		1/1	R1*	
QC:		Date:	SPC (Y/N):		Date:		•	Stop	*N	R2*	
ID	Operation Description		Set Up/ Run Hours	Tool II	O Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
	QC8- Inspect parts - sec	ond check	0.00	1.			•	1		DAG	
	Мето		0.00	OFC/B.A	2013-11-	08	6	\$		~82 08	
					-						
	Chemical Conversion C	Coat per QSI005 4.1	0.00				<i>(</i>	A 11	- 17 11	1-9	
	Memo		0.00				<u> </u>	-740	7151		
	M 136 X39 Memo STARTIU	ME: ZX	0.00	E:			6	ф 12	3 10 11	DA 34 9-8	S 4 39
	D2938-1 206 Saddle I 10/29/13 2: 10/29/13 Process P	D2938-1 206 Saddle Left Side 10/29/13 Start Qty: 4.00 2: 10/29/13 Req'd Qty: 4.00 Process Plan: QC: Operation Description QC8- Inspect parts - sec Memo Chemical Conversion C Memo	D2938-1 206 Saddle Left Side 10/29/13 Start Qty: 4.00 *4* 10/29/13 Req'd Qty: 4.00 *4* Process Plan: Date: QC: Date: Operation Description QC8- Inspect parts - second check Memo Chemical Conversion Coat per QS1005 4.1 Memo White Gloss(Ref 4.3 5.1) per QS1005 4.3-Alum Memo START TIME: Memo	D2938-1	D2938-1	D2938-1	D2938-1	D2938-1	D2938-1	D2938-1	D2938-1

DQA:		 	Date:			WORK ORDER NON	~	ONICO	DRAABICE / LU					₹	DART
QA Closed:			Date:			WORK ORDER NON-	-C(JNFUI	RIVIAINCE / UI	PDATE	W	ork Order up	odate only	7 -	AEROSPACE
Work Orde	`					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS		
Part N	-					Rework		 - -	Skid-tube	Crosstube Small Fab	_	Due.	Water Jet	En	gineering
NCR N	-				<u> </u>	Scrap Use-as-is Suspected Unapproved			Machining noforming Large Fab	Finishing Composite			d. Eng. Coor. re/Packaging Supplier		Quality Other
Root	T				Desc	ription of work order update		Initial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	1	nief Eng		ription		Date	Verification	1 (QC Inspector
Design				,							-		V C	 	ac mopeoto.
Doc/Data					•										
Equip/Tooling	П														
Handling/Pre	П													1	
Material															
Operator	Н												•		
Offset/Setup	\dashv														
Process	Н												-		
Supplier	\vdash														
Training	\vdash														
Transport	Н														
Unapproved	Н														
этарртотса				<u> </u>	L		ΕΛI	LILT CAT	regory			l			
Landi	nø G	ear				General		OLI CA	LOOKI						
		Bending				Bend	Г	leglio/E	rogram			Outside Dim	i	٦,,,,	
,	-	Centre No	nt Concer	ntric	-	BOM/Route	┝	Grain	TOGIAIII		┝		⊢	⊣	sure/Forced
	_	Cracks	i concer	itiit	-	Broken/Damage/Defect	-	Hardwa	ro.		_	Over/Under	 	Set-	
,	-	Crimp/Kin	k/Rinnla	/Mayo	-	Burrs	<u> </u>	+ .			┝	Part Incorred		—	perature/Cure
	_	Cuffs	ik/ itippie,	, wave	-	Contamination	⊢	1 `	on Incomplete/Ur	•	_	Part Lost/Mi	ssing	Weld	
		Crushing			<u> </u>	Countersink	-	-1	ions Incomplete/L	Inclear	┝	Part Moved		JWro	ng Stock Pulled
	_	Heat Trea			-	Cut Too Short		Mislabe	ned/off center		<u> </u>	Positioned V		٦	
	-	neat frea Inspection		Tubo	-		⊢	4			<u> </u>	Power Loss/	Surge	Othe	er
!	$\overline{}$	mspection Marks/Ch		rube	\vdash	Drawing Drill Holes		Misread	1						
	$\overline{}$				-		-	Off-set	S 191						
	-	Turning So			-	Finish	<u> </u>	4	Calibration					 	
	1 1	Wave/Tw	ist in Tub	e	1	Fit/Function	I	1Out of 9	Seguence						

October-29-13 10:13:15 AM

October-29-13	10.13.13 A1	M.							-= :=-:=				
Item ID: Revision ID:	D2938-1			Accept		*N9(\mathcal{O}	040	100)* s	etup Star	I XI	S1*
Item Name:	206 Saddle I	Left Side									Sto	' *N ;	S2*
Start Date: Required Date:	10/29/13 10/29/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*			Cust It		D:					
Reference:		-	-										
Approvals:	Process P	lan:	Date:	Tooling	g:		Da	ıte:	<u></u>	R	tun Star	17	R1*
	QC:		Date:	SPC (Y	// N):		Da	ite:			Sto	° *N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Run	Up/ Hours	Tool	ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		QC3- Inspect Part Finish		0.00	DAS					ſ			
160		Memo		0.00	27 9-89					φ_			
Quality Control		·			BILI	1							
170		Identify as per dwg & Sto	ock Location	? 0.00						r.			DAS
170 Packaging		Memo	•	0.00						6x			26 9-89
Packaging		WEIIIO										(3-11-
. 180		QC21- Final Inspection -	- Work Order Release	0.00									
180		QODI Tima mopeetion								40	LJ_	3-71-	3
QC		Memo		0.00						Jot.:	<u> </u>	<u> </u>	mF
Quality Control													mu

1311-10

DQA:		_ Date:											***	
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UF	PDATE	W	ork Order up	odate only	_	AEROSPACE
Work Orde	ar:				DISPOSITION				AGAINST		PARTMENT	•		
WOIR Olde					Rework	ıl		Skid-tube	Crosstube	F	1	Water Jet	\neg	F
Part N	lo				Scrap			Machining Machining	Small Fab	-	Pro	d. Eng. Coor.	\dashv	Engineering Quality
NCR N	lo				Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	re/Packaging Supplier		Other
Root				Desci	ription of work order update		nitial	Acti	ion		Sign &		Т	
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption		Date	Verification	,	QC Inspector
Design									·				T	~ \
Doc/Data														*
Equip/Tooling														
Handling/Pre													ĺ	
Material														
Operator								·						
Offset/Setup														
Process														,
Supplier														
Training														
Transport														
Unapproved													5.3	1.a. —
						FAL	ULT CAT	TEGORY			•			
Landir	ng Gear		_	-	General									
Į	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	\Box F	Pressure/Forced
1	Centre N	lot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	\exists_{S}	Set-up
]	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorred	ct [Пт	emperature/Cure
	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	\neg _v	Veld
	Cuffs				Contamination		Instruct	ions Incomplete/U	nclear		Part Moved		\neg $_{v}$	Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned W			-
	Heat Tre	at			Cut Too Short		Mislabe	eled			Power Loss/S		\neg c	Other
	Inspection	on Strip in	Tube		Drawing		Misread	1			•	- L		
	Marks/C	hatter			Drill Holes		Off-set							
[Turning :	Sequence			Finish		Out of (Calibration						
	Wave/Tv	vist in Tub	e		Fit/Function		Out of 9	Sequence						

Required Date: 10/29/13

Required Qty: 4.00

Start Date: 10/29/13

Start Qty: 4.00

Picklist Print

October-29-13 10:13:15 AM

Work Order ID:

108897

Parent Item:

Comments:

D2938-1

Parent Item Name:

206 Saddle Left Side

IPP: B 00.06.26 New DWG rev (mpp 2069)EC IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No		- which is severe for	100	Each	7.0000	1	4			
Saddle Billet, 7075													
				Location		Loc Oty	<u>L</u>	oc Code					
				MAT042		1							
				10359	92	1							
				MAT045		6							
				97563	3	6							
				1083	29 % —				_> la	4	K 1	3/1/6	\ 2

DQA:			Date:										* 7)/3	
OA Classel			D-4			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	14/	ork Ordor un	data anly	<i>موری کی ا</i> A <i>E F</i>	ROSPACE
QA Closed:			Date:							VV	ork Order up	date only	-	····
Work Orde	er:					DISPOSITION	,		AGAIN	ST DE	PARTMENT	PROCESS		
	_					Rework			Skid-tube Crosstu	oe 🗀]	Water Jet	Enginee	ring
Part N	10.					Scrap			Machining Small F		Pro	d. Eng. Coor.		ality
	_					Use-as-is		Thern	noforming Finishi	ng	Rec/Stor	e/Packaging] o	ther
NCR N	۰ lo.					Suspected Unapproved			Large Fab Composi	te]	Supplier		
Root	•				Desci	ription of work order update		nitial	Action		Sign &		T	
Cause	ļ	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC In:	spector
Design						,								
Doc/Data													1.	
Equip/Tooling														
Handling/Pre														
Material														
Operator												;		
Offset/Setup														
Process							l				,			
Supplier							l							
Träining] 											
Transport														
Unapproved			<u> </u>				<u> </u>							
							FA	ULT CA	TEGORY					
Landii						General		1	_		٦.	Γ	- ,	
	\vdash	Bending				Bend	<u> </u>	1	Program	\vdash	Outside Dim	<u> </u>	Pressure/F	orced
	—	Centre No	ot Concer	ntric	<u> </u>	BOM/Route	_	Grain		-	Over/Under	} -	Set-up	
	\vdash	Cracks		6	-	Broken/Damage/Defect	<u> </u>	Hardwa		-	Part Incorred	⊢	Temperati	ure/Cure
	-	Crimp/Kir	ik/Ripple	/Wave		Burrs	<u> </u>	4	ion Incomplete/Unqualified	-	Part Lost/Mi	ssing	Weld	
	—	Cuffs				Contamination	<u> </u>	-	tions Incomplete/Unclear	-	Part Moved	<u>L</u>	Wrong Sto	ock Pulled
	-	Crushing			\vdash	Countersink	\vdash	-	gned/off center	\vdash	Positioned V		٦	
	—-	Heat Trea			-	Cut Too Short		Mislabe		L	Power Loss/	Surge	Other	
	-	Inspection		Tube	-	Drawing	_	Misrea						
	-	Marks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set					· · · · · · · · · · · · · · · · · · ·	
	—	Turning S			<u> </u>	Finish	_	4	Calibration					
I	ı l	Wave/Tw	ust in Tur	26		Fit/Function	1	1Out of	Seguence					

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	108897
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Red	ons				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.133	.132	. 132	.132		
В	0.100	0.140		133	.132	. /32	./32		
С	0.100	0.140		.116	.115	116	.116		
D	0.210	0.230		1.221	. 222	,222	.222		
E	1.245	1.255		1.250	1.257	1.250	1,250		
F	1.245	1.255		1.250	1,250	1.250	1.250		
G	2.495	2.505		2.500	2,500	2.500	2,500		
Н	0.510	0.515		. 572	. 572	- 572	.572		
T	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2,500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.315	.315	.3/5		
М	0.235	0.240		.236	.236	-236	,236		
N	0.100	0.140		124	.124	.124	.124		
0	0.540	0.560		548	546	.546	.547	***	
Р	0.490	0.510		.500	.501	.499	500		
Q	3.715	3.725		3.72h	3.720	3.720	3.720		
R	2.720	2.760		2.743	2,743	2.743	2,743		
S	0.240	0.270		.252	.251	.250	.250		
Т	0.100	0.180		.140	140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1368	1.368	1.368	1.368		
W	0.316	0.321		1.3/7	.3/7	.3/7	.317	,	
X	1.250	1.270		1,260	1.260	1.261	1.2101		
Υ	1.565	1.585		1.574	1.574	1.576	1.576		
Z	0.178	0.198		188	.188	-188	. 188		
AA									
AB				Ţ					
AC									
AD									
AE									
AF									
AG									
AH									
	Acc	ept/Reje	ct						

1		
Measured by:	Audited b	by JR/B. DAS
Date: /3/1/25	Date	e: 2013-11-08 U8
		W.80

Rev	Date	Change	Revised by	Approved
Α		New Issue	RF	
В	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM 🔏	Jul

DART AEROSPACE LTD	Work Order:	108897
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

<u> </u>				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	3	4	Ву	Date
Α	0.100	0.140		./3/	. /33				
В	0.100	0.140	•	-131	. /33				
С	0.100	0.140		1,117	.116				
D	0.210	0.230		. <i>22</i> 3	.223				
Е	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2,500_	2,500				
Н	0.510	0.515		-572	.572				
ı	1.572	1.582		1577	1.577				
J	2.495	2.505		2,500	2.500				
K	0.257	0.262		.259	.259			_	
L	0.312	0.317		.315	.3/5				
М	0.235	0.240		1.23/	.236				
N	0.100	0.140		124	.124			_	
0	0.540	0.560		.547	.248				
P	0.490	0.510		J,50D_	.500				
Q	3.715	3.725		3.720	3.720				
•R	2.720	2.760		2.743	2.743				
S	0.240	0.270		.250	.257				
Ť	0.100	0.180		.140	.140				
Ū	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.368	1.368				
W	0.316	0.321		1.3/7	1.3/2				
Х	1.250	1.270		1.260	1.262				
Υ	1.565	1.585		1.575	1.577				
Z	0.178	0.198		188	1.188_				
AA									
AB					 				
AC					<u> </u>				
AD					 				
AE						ļ			
AF					<u> </u>	<u> </u>			م)
AG									
AH									
	Ac	cept/Reje	ect	}			<u> </u>		

	Audited by Cos / b MAS
Measured by:	Audited by Orcy A A 200
Date: 13/1/05	Date: 20/3-11-08 08

Rev	Date	Change	Revised by	Approved
A		New issue	RF	
B	02 12 12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	-1
C		Revised per drawing revision C	KJ/JLM C	
	07.00.21		γ, ()	/~/



